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Canada

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D205-634-041
Job Sheet 197140



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/2/19

Job Tracking No:

Due Date: 7/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs	7/30/19	7/30/19	0.00	0.65	Skidtubes - Bend		Mac
120	Skidtubes - 2 - B4B	1 pcs	7/30/19	7/30/19	0.00	2.89	Skidtubes - 1 - B4B		DO
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs	7/30/19	7/30/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Skidtubes - 3 - B4B	1 pcs	7/30/19	7/30/19	0.00	3.00	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		

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150 QC 10	1 pcs	7/30/19	0.00 0.00	Skidtubes - 3 - B4B	MCC TF BB
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 10 - 10	
				QC 10 - 18	
160 QC 5	1 pcs	7/30/19	0.00 0.00	QC 10 - 24	DAS AUG 08 2019 50 9-89
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	7/30/19	0.00 1.31	QC 5 - 17	DAS AUG 08 2019 68 9-89
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	DAS AUG 12 2019
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 -	

				B4B	
				Handfinish - 1 - 22 - B4B	
180 Powdercoat - 1 White GI(A)-B4B	1 pcs	7/30/19	0.00 0.34	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	BEB 19-08-13
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
190 QC 3	1 pcs	7/30/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	MI 19-8-13
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
200 Handfinish - 4-1-Assembly-B4B	1 pcs	7/30/19	0.00 1.00	Handfinish - 4 - 1 - B4B	MI 19-8-13
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
210 QC 5	1 pcs	7/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	DAS
				QC 5 - 19	81
				QC 5 - 22	9-89
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				Plex 7/2/19 9:06 AM Dart.lajeunesse.marie	

DAS
15
9-89

				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
220 Packaging 3-1 - Stock - B4B	1 pcs	7/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
225 DC - 1 - B4B	1 pcs	7/30/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	AUG 26 2019
230 QC 21 - FG	1 pcs	7/30/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	AUG 26 2019

Part Op 110 - Skidtubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe Descriptions: batch# in aft end of tube
120 - Skidtubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004
130 - QC5- Inspect part completeness to step on W/O
140 - Skidtubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr 5-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr
150 - QC10- Inspect visual per QSI004- ground welds
160 - QC5- Inspect part completeness to step on W/O

AK 139011

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

5139459. 180 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 1.20 OVEN TEMPERATURE: 375°
FINISH TIME: 1.35

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 5163437 Sikaflex expire date: 19-12-9 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 5163432 Sikaflex expire date: 19-12-9 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 5185147

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: PPP Rev:

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - Bend - 1	5192377
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skidtubes - 3 - B4B	5177095
D4202-1	Spacer	20 pcs (20 ea)	140-Skidtubes - 3 - B4B	5154382
ALS7-1032-130	Rivnut 5159769 (426)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5196021 (24)
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5149158-1
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5192134
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5189025
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5173297
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5173297
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5194524
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5185057
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196224
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5185270
NAS1149C0332R	Washer (AN960C10L)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5186896
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5193130
				5178320

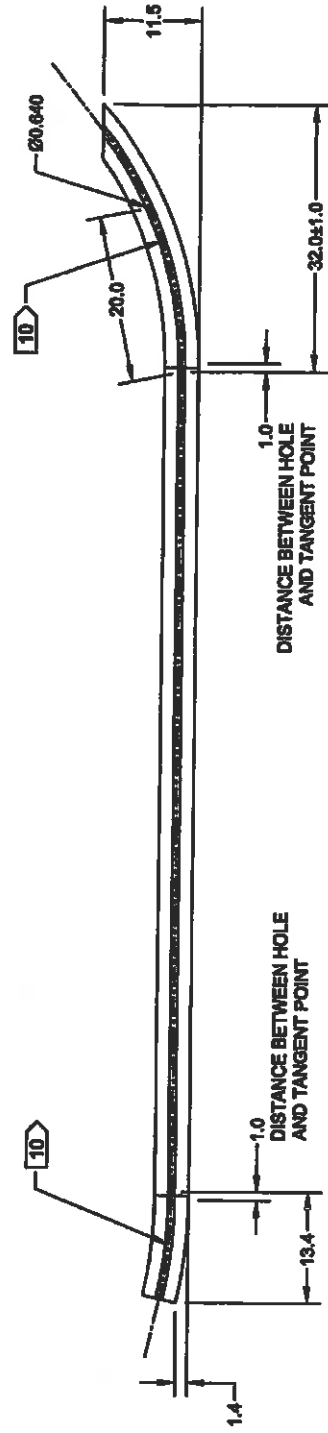
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	4	0
140-Skidtubes - 3 - B4B	D2576-3	1	35	0
	D4202-1	20	601	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,404	0
	AN3-5A	2	154	0
	AN3C4A	50	1,357	0
	D2594-1	16	82	0
	D2594-3	16	227	0
	D2855	1	97	0
	D3564-11	1	7	0
	D3564-13	1	2	0
	D3564-5	1	3	0
	D3564-9	1	5	0
	NAS1149C0332R	50	4,682	0
	NAS1149D0332J	2	3,254	0

Part Specifications

Specifications could not be found.

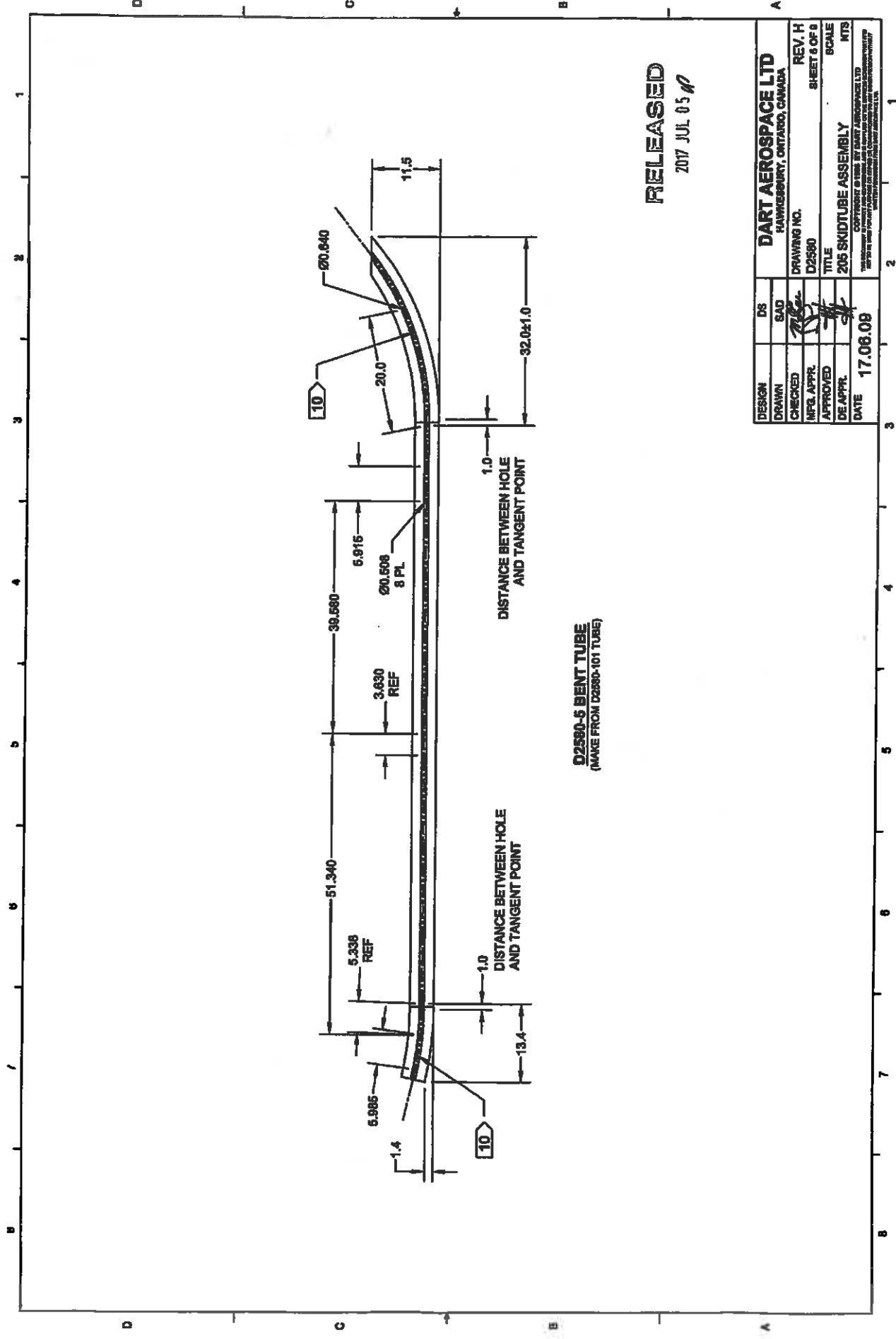
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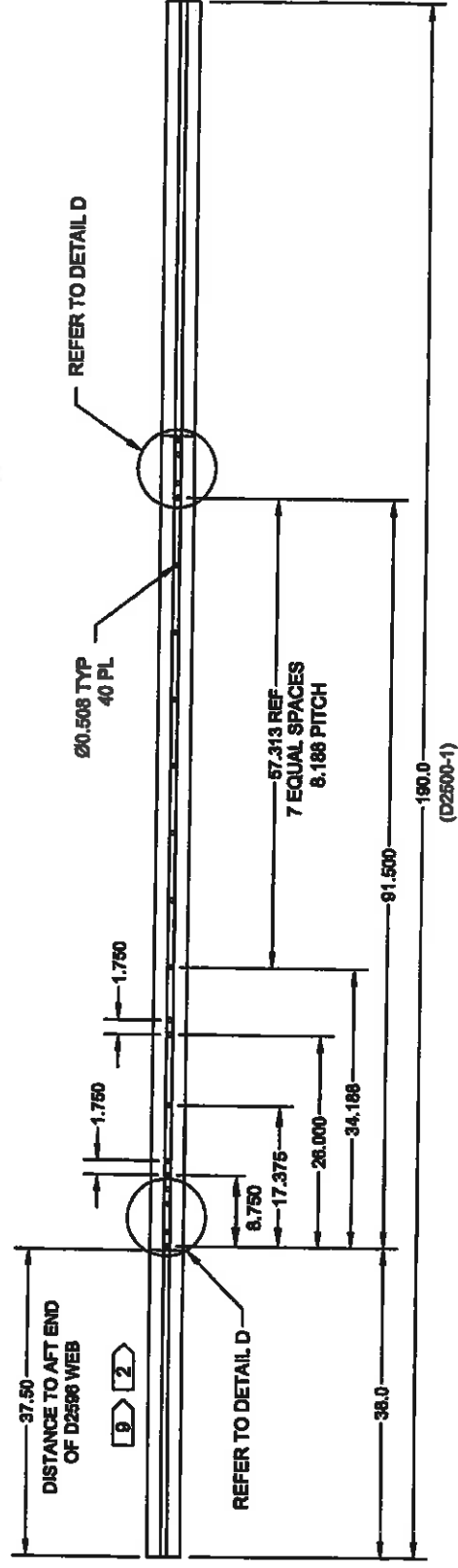


D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

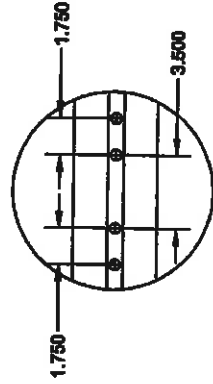
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2017 JUL 05 q

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	WSE	DRAWING NO. D2580
MFG. APPR	WSE	REV. H SHEET 3 OF 9
APPROVED	WSE	TITLE 208 SKIDTUBE ASSEMBLY
DATE	17.08.08	SCALE NTS
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D2568-101 TUBE



DETAIL D
SCALE 6X

RELEASED
2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	MANICEBURY, ONTARIO, CANADA
CHECKED	MS	DRAWING NO. D2568
INFO. APPR.	MS	REV. H SHEET 9 OF 9
APPROVED	MS	TITLE 205 SKIDTUBE ASSEMBLY
DATE	17.06.09	SCALE NTB

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Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation		Disposition					
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread					